

Work Order ID 142793

Friday, March 11, 2016 1:09:19 PM

142793

Page 1

Item ID: D2621 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Latch Plate
 Start Date: 3/31/2016 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 4/8/2016 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: MLS Date MAR 14 2016 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2621	Rev B								

100 FLOW WATER JET 0.00
100
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D2621 Dwg Rev: B Prog Rev: B 2-
 Deburr if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00
 Quality Control

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00
 Quality Control

(10) _____ DC 16/04/05

(10) _____ DC 16/04/05

(10) _____ DAS
 16
 3.80
 16/04/06

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.00							
Hand Finishing									
140	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
140									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <u>1:10</u> OVEN TEMPERATURE: <u>325</u> FINISH TIME: <u>1:40</u>								
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									

DAS
38
9-89
APR 14 2016

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>ST009</u>	0.00							
160									
Packaging	Memo	0.00				<u>10</u>	<u>MLJ</u>	<u>1604-14</u>	
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.02				<u>MLJ</u>		<u>APR 14 2016</u>	
Quality Control									

2m 16/04/14.MLJ APR 14 2016

DQA: _____ Date: _____



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		☐ OTHER : _____							

Picklist Print

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Work Order ID: 142793

142793

Parent Item: D2621

D2621

Parent Item Name: Latch Plate

Start Date: 3/31/2016

Required Date: 4/8/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: C02.02.28 Added inspection level 8 and level 5 SM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.040		Purchased	No			110	sf	53.7519	0.0625	0.657895			

M5052H32S 040

5052-H32 .040 Sheet

ac 16 / 04 / 05

Location

Loc Qty

Loc Code

MAT023

53.7519262

m129530

4.0984

m132540

4.9535262

m133550

24.7

m1342217

20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

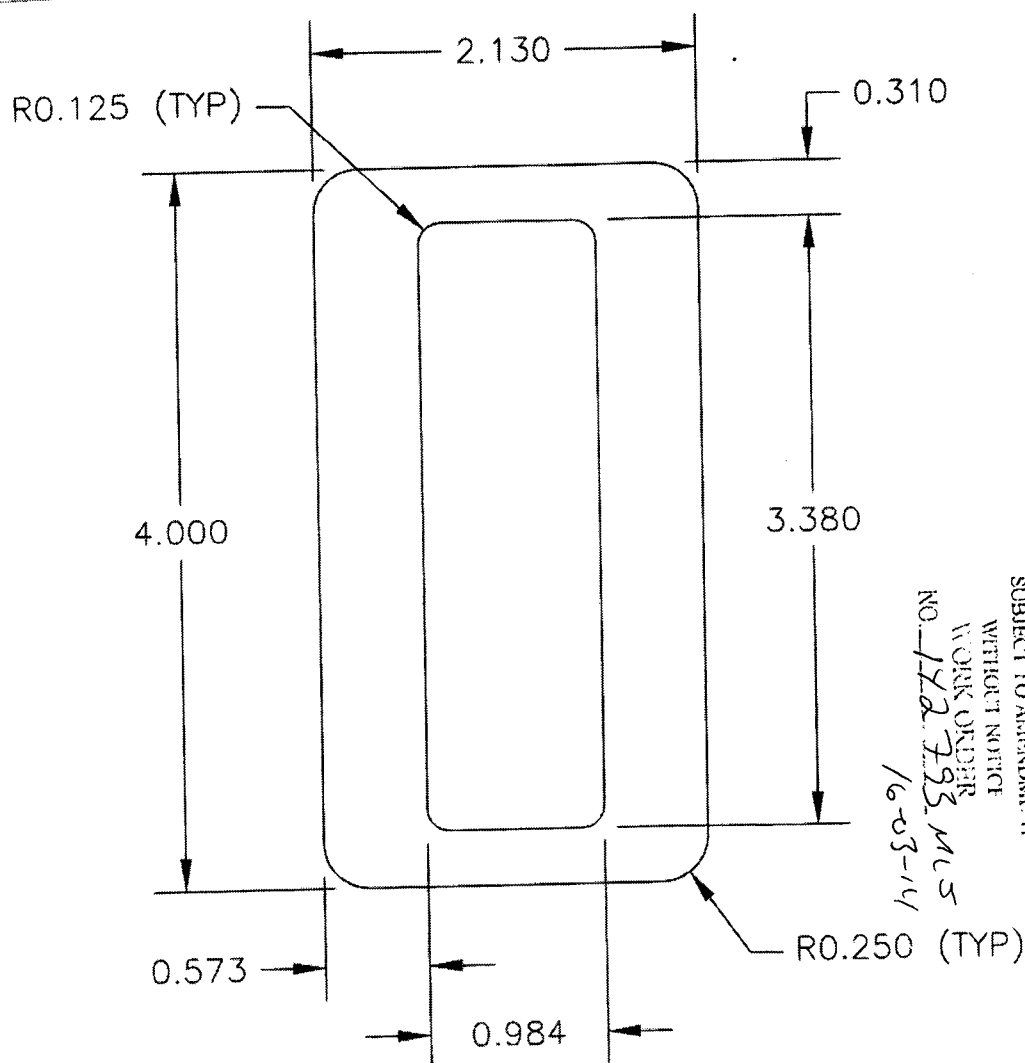
Work Order update only ☐

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OTHER : ☐					



DESIGN BW	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2621	REV. B SHEET 1 OF 1
DATE 00.06.01		TITLE LATCH PLATE	SCALE 1:1
A	96.08.15	NEW ISSUE	
B	00.06.01	ADDED FINISH; R0.125 WAS R0.118	

RELEASED
00.06.05 *[Signature]*



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 172.795 MLS
16-03-14

MATERIAL: 5052-H32 (QQ-A-250/8) OR 6061-T6 (QQ-A-250/11) OR 2024-T3
(QQ-A-250/4) 0.040 THICK
FINISH: CHEMICAL CONVERSION COAT PER DART 005 4.1
POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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